

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave.St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-023902**Date Inspected:** 21-May-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** ShangHai, China**CWI Name:** Shi Yu**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

Summary of Items Observed: On this date Caltrans OSM Quality Assurance(QA) Inspector, DJ Shin was present during the times noted above for observations relative to the work being performed.

**Bay 1**

This QA Inspector observed the following work in progress for Bay 1.

ZPMC perform SAW and FCAW welding on lifting lug and grinding work on the hand rail and lifting lug,

**Bay 9**

This QA Inspector observed the following work in progress for Bay 9.

ZPMC perform grinding work on hand rail and Saddle Housing sub assembly,

**Bay 11**

This QA Inspector observed the following work in progress for Bay 11.

ZPMC perform fit up process on BK011A.

**Trial Assembly yard**

This QA Inspector observed the following work in progress for Trial Assembly.

ZPMC was using the Flux Core Arc Welding (FCAW) process.

ZPMC QC is identified as Li Yang

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specifications (WPS). Listed below are the locations that were identified by this QA inspector.

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## WELDING INSPECTION REPORT

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Components: 13AW  
PCMK: SEG3013J-164,178  
Welder: 062708  
WPS-B-T-2133-ESAB

Components: 13AW  
PCMK: SEG3013T-170,184  
Welder: 048433  
WPS-B-T-2133-ESAB

Components: 13BW  
PCMK: SEG3122-002,008  
Welder: 045143  
WPS-B-T-2131-ESAB

This QA Inspector observed the following work in progress for Trial Assembly.  
ZPMC was using the Shield Metal Arc Welding (SMAW) process.  
ZPMC QC is identified as Li Yang.  
Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).  
Listed below are the locations that were identified by this QA inspector

Components: 13AW  
PCMK: SEG3013-098  
Welder: 047864  
Report: B-WR-20695  
WPS-345-SMAW-3G(3F)-FCM-Repair-1

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

### Summary of Conversations:

No relevant conversations

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Shin,DJ	Quality Assurance Inspector
<b>Reviewed By:</b>	Riley,Ken	QA Reviewer

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